

Date: Monday, 8/21/2006 2:11:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 28254A		
Estimate Number	: 10338		
P.O. Number	: N/A	Part Number	: D2657
This Issue	: 8/21/2006 S.O. No. : N/A	Drawing Number	: D2657 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 27218	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 9/12/2006
Checked & Approved By	: <i>[Signature]</i> 06.08.21	Qty:	30 Um: Each
Comment	: Est Rev: A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.1925 f(s)/Unit Total : 5.7740 f(s)
 Material: ASTM A36 steel bar 2.50" x 0.75" thick
 (M1010-B0.750 x 02.500)
 Batch 101926

SA

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.200" long

SA 06.08

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA040 and Dwg D2657

2-Deburr

En/SA 06.08.28

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En/SA 06.08.28

5.0	QC8	SECOND CHECK
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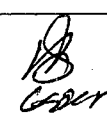
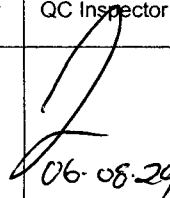


Comment: SECOND CHECK

JLM 06/08/29

30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/29	3	2 Part SCRAP. Part came out of use		Scrap 1 destroyed and Replaced.	En 06/08/29	 06-08-29		 06-08-29

Part No: _____ PAR #: _____ Fault Category: _____

NCR: Yes ☒ No ☐ DQA:  Date: 06/08/30

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5154

AB 06/08/29 (30)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/30

Job Completion



C Loc 108/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

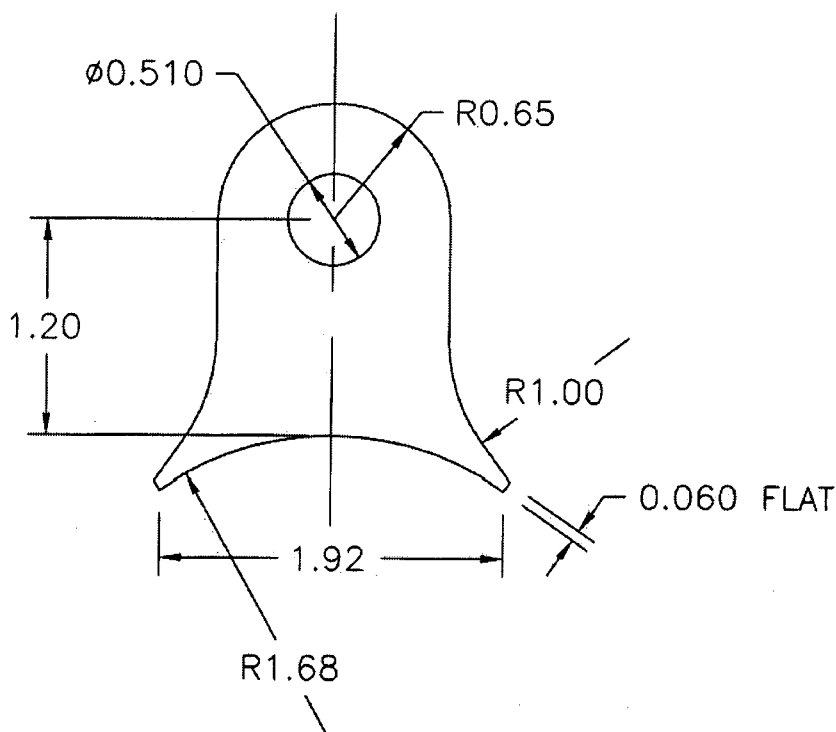
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2657	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG	SCALE 1:1
A	97.11.03	NEW ISSUE	

RELEASED
97/11/07 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
MATERIAL: ASTM A36 STEEL 0.375 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE

SHOP COPY
REVIEWED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28254A